

Date: Monday, 5/28/2007 7:58:02 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUPPED WASHER
Job Number : 32693	
Estimate Number : 12885	
P.O. Number : N/A	Part Number : D36281
This Issue : 5/28/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW
Prsht Rev. : NC	Project Number : IA0002
First Issue : N/A	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 6/4/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 600
Comment : Est Rev: A New Issue 07-05-28 JLM	Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S18GA

304/316 .050 Sheet



Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.5145 sf(s)

304/316 .050 Sheet

Batch: M100997

ml 07 05 29

(14)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg d3628

Dwg Rev: U/R

Prog Rev: U/R

ml 07 05 29

(14)

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 05 29

(14)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 07 05 29

(14)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3628

ml 07 05 29

(6)

Need only 6
 scrap & flat pattern

Date: Monday, 5/28/2007 7:58:03 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 32693

Part Number: D36281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.05.07.29(6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ENG APPROVAL
LE 07.05.29.

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

20.05.30

Job Completion



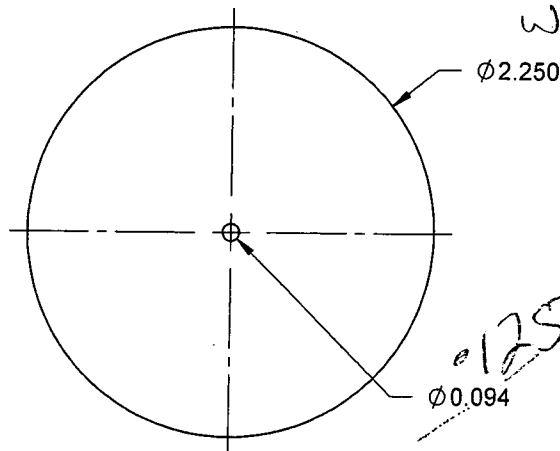
job.00067A

LE 07.05.30

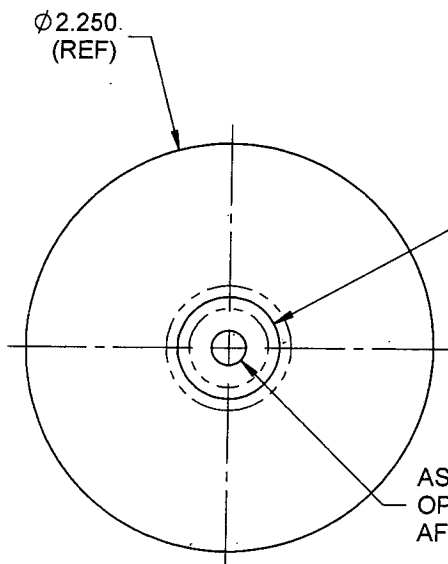
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3628	REV. A SHEET 1 OF 1
DATE 07.05.07	TITLE CUPPED WASHER		SCALE 1:1
REV A	DATE 07.05.07	DESCRIPTION NEW ISSUE	

REFERENCE ONLY



D3628-1F FLAT PATTERN

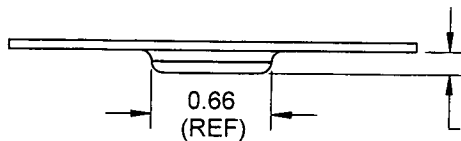
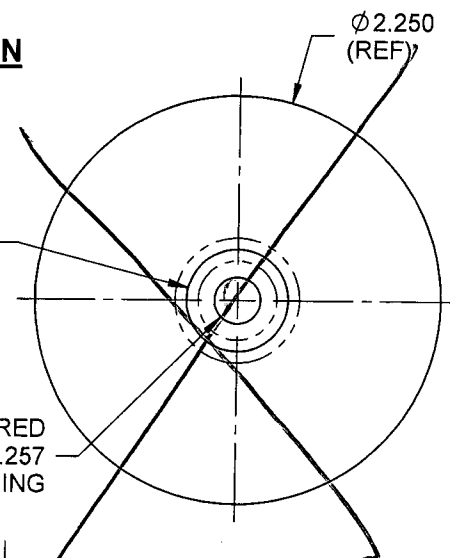


PUNCH Ø0.56 x 0.13 DEEP

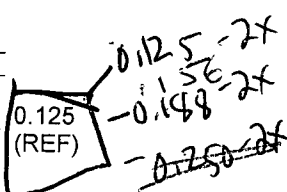
PUNCH Ø0.56 x 0.13 DEEP

AS REQUIRED
OPEN TO Ø0.191
AFTER PUNCHING

AS REQUIRED
OPEN TO Ø0.257
AFTER PUNCHING



D3628-1 CUPPED WASHER



D3628-3 CUPPED WASHER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 32693
Description: Cupped Washer		Part Number: D3628-1
Inspection Dwg: 8UR	Rev: 1/R	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 2.250$	$\pm 0.012-0.001$	2.253	✓		Vern	
B 0.050	± 0.010	0.046	✓		Vern	
C $\phi 0.125$	± 0.001	$\phi 0.125$	✓		Vern	
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ML ML	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 07.05.29	Date: 07.05.29	Date: 07.05.29
Rev	Date	Change
		New Issue
		Revised by KJ/RF
		Approved